इंटरनेट मानक

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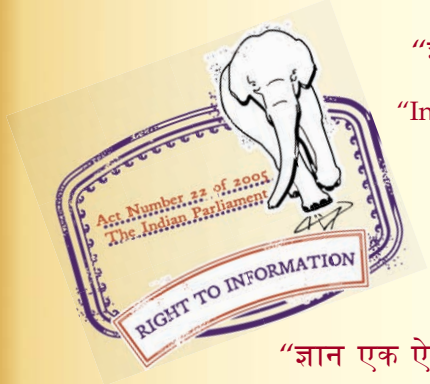
IS 11029 (1984): Steering Ball Races for Mopeds [TED 2: Automotive Primemovers]



"ज्ञान से एक नये भारत का निर्माण"
Satyanarayan Gangaram Pitroda
"Invent a New India Using Knowledge"

"ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है"
Bhartṛhari—Nītiśatakam
"Knowledge is such a treasure which cannot be stolen"

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(Reaffirmed 2000)

Indian Standard

SPECIFICATION FOR STEERING BALL RACES FOR MOPEDS

1. Scope — Covers requirements for steering ball races for mopeds.

2. Shape and Dimensions — The shape of steering ball races and their critical dimensions shall be as recommended in Fig. 1 to 4. Entry chamfers/radii shall be provided as indicated in the figures for easy assembly. The radius of the ball track shall be at least 0·15 mm more than the radius of the balls used in the assembly. Suitable skirting or any other alternative arrangement to avoid ingress of dust shall be provided on the cup-bottom and cone-top. The recommended diameter of pivot tube and balls are 25·4 mm and 3·969 mm, respectively.

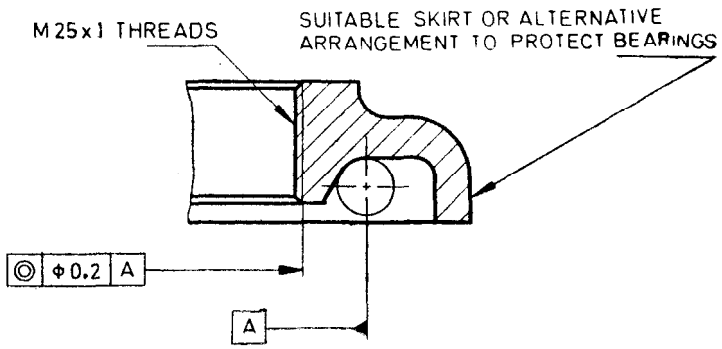

FIG. 1 CONE TOP

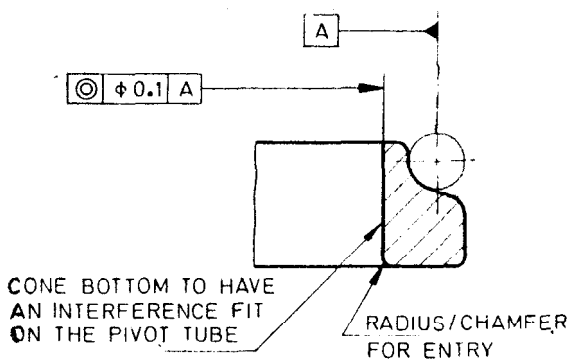

FIG. 2 CONE BOTTOM

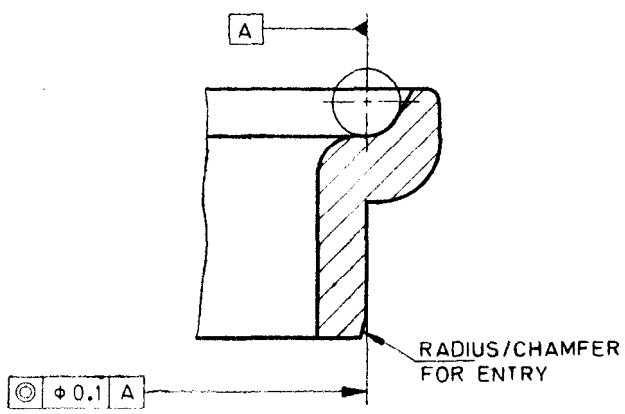

FIG. 3 CUP TOP

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Mopeds Sectional Committee, EDC 78 [Ref: Doc : EDC 78 (3874)]

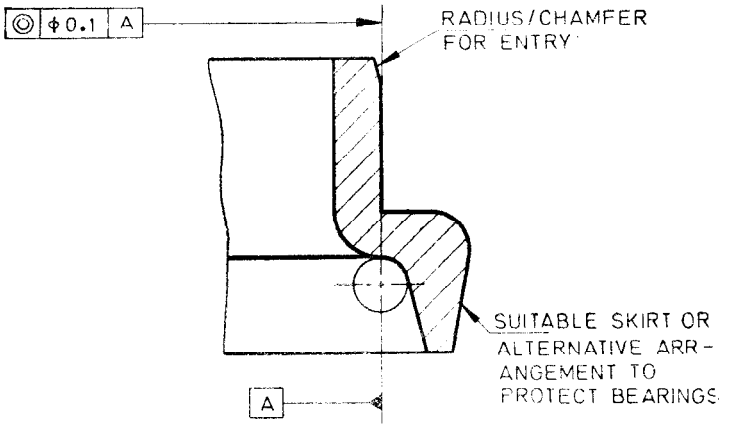

FIG. 4 CUP BOTTOM

3. Material — The material used shall be case hardening steel of 15 Cr 65 conforming to IS : 4432-1967 'Specification for case hardening steels'. Alternatively, the steel used shall have a tensile strength not less than 550 MPa (55 kgf/mm^2) in the core after case hardening.

4. General Requirements — The steering races shall be smooth and free from burrs. The edges shall be rounded off to prevent cuts and nicks. The concentricity of the components shall be as given in Fig. 1 to 4. The surface finish of ball track shall be at least 0·3 Ra.

5. Hardness — The hardness measured at points case hardened shall be 590-650 HV with a case depth of 0·4 to 0·6 mm.

6. Finish — The ball track of the steering races shall have a smooth finish. The races shall be chemically treated against corrosion or zinc plated to service condition number 2 of IS : 1573-1970 'Specification for electroplated coatings of zinc on iron and steel (*first revision*)'. In case of zinc plating, hydrogen de-embrittlement shall be ensured after plating. If nickel and chromium plated, it shall conform to service grade No. 1 with designation SNi 10b Cr r of IS : 1068-1968 'Specification for electroplated coatings of nickel and chromium on iron and steel (*first revision*).

7. Tests — The steering races shall be visually examined for any manufacturing defects. A suitable load test as agreed to between a purchaser and the suppliers shall be carried out on each race. At the end of the test, the steering race shall show no rupture or tear.

8. Packing — The steering races shall be wrapped in oil coated paper and packed in cartons.

9. Marking — Manufacturer's trade name or trade mark may be embossed or punched on components.

9.1 *ISI Certification Marking* — Details are available with Indian Standards Institution.

10. Sampling — Unless otherwise agreed upon between a supplier and purchaser the inspection sampling shall be as per IS : 2500 (Part I)-1973 'Sampling inspection tables : Part I Inspection by attributes and by count of defects (*first revision*)'.

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